

Work Order ID 62646

Wednesday, October 06, 2010 8:13:41 AM



Page 1

Item ID: D3195-043

Revision ID:

Item Name: Bracket Assembly

Start Date: 10/6/2010 Start Qty: 4.00

Required Date: ~~10/15/2010~~ Req'd Qty: 4.00

Reference: NOV. 1

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: *PL*Date: *10-10-06*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3195

Rev A

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blanks: (1.250" x 1.500") x 3.60" long

0.00

0.00

*OK 10/11/04**4**0*

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine D3195-3 as per Folio FA334 and Dwg D3195-3□2-Deburr

0.00

0.00

*G.A 10/11/04**4**0*

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

*G.A 10/11/04**4**0*

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Page 2

Item ID: D3195-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 10/6/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

and 10/11/04

QC

Memo

0.00

4 0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

4 BL 10-11-11

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

4 BL 10-11-8

Powder Coating

START TIME:

1:20

OVEN TEMPERATURE:

320° FINISH TIME:

1:50

Work Order ID 62646

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Page 3

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Start Date: 10/6/2010 Start Qty: 4.00

Required Date: 10/15/2010 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: _____ Date: _____

Tooling:

Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

=) JU 10/11/08

0.00

Memo

4

Ø

170



Small Fab

Small Fab

Small Fab

0.00

0.00

Memo

1-Lightly Sand bonding surface 2-Bond D3195-7 into D3195-13as per Dwg
D3195 A/RContact Cement 11/10/05

E 5/10/11/16 (4)

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

S. White

(X4)

Work Order ID 62646

Wednesday, October 06, 2010 8:13:41 AM



Page 4

Item ID: D3195-043

Revision ID:

Item Name: Bracket Assembly

Start Date: 10/6/2010 Start Qty: 4.00

Required Date: 10/15/2010 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



Packaging

Packaging

Identify as per dwg & Stock Location: 246A

0.00

Memo

0.00

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/11/17

10/11/17

Picklist Print

Wednesday, October 06, 2010 8:13:46 AM

Page 1

Work Order ID: 62646

Parent Item: D3195-043

Parent Item Name: Bracket Assembly




Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3195-7 		Manufactured	No			100	Each	0.0000	1	4			
Pad M6061T6B1.500X01.25 0 		Purchased	No			170	f	39.0492	0.3	1.263158			
6061-T6 Bar 1.50 x 1.25 													

B62723 (4)

FS 10/11/16



Location

MAT10

107461

→ 110936

Loc Qty

39.04915

11.26315

27.786

Loc Code

1.263 amb 10/11/04

DART AEROSPACE LTD		Work Order:	62046
Description: Bracket		Part Number:	D3195-3
Inspection Dwg: D3195 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.432	+/-0.010	3.434	✓		Vern	GA -01
1.265	+/-0.010	1.257	✓		"	"
R0.37	+/-0.030	R0.37	✓		R-G	ref.
Ø0.277	+0.005/-0.000	Ø0.279	✓		Vern	GA -01
2.677	+/-0.005	2.677	✓		"	"
0.242	+/-0.010	0.247	✓		"	"
0.377	+/-0.010	0.380	✓		"	"
0.500	+/-0.010	0.502	✓		"	"
R0.188	+/-0.010	R0.188	✓		R-G	ref.
0.250	+/-0.010	0.251	✓		Vern	GA -01
0.882	+/-0.010	0.880	✓		"	"
1.250	+/-0.010	1.252	✓		"	"
0.500	+/-0.010	0.499	✓		"	"
Ø0.191	+0.005/-0.000	Ø0.192	✓		"	"
1.000	+/-0.010	1.002	✓		"	"

Measured by:	HA	Audited by:	amf	Prototype Approval:	N/A
Date:	10/11/04	Date:	10/11/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-013)	KJ/RF	
B	05.04.26	R0.37 was R0.037; 1.084 removed	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

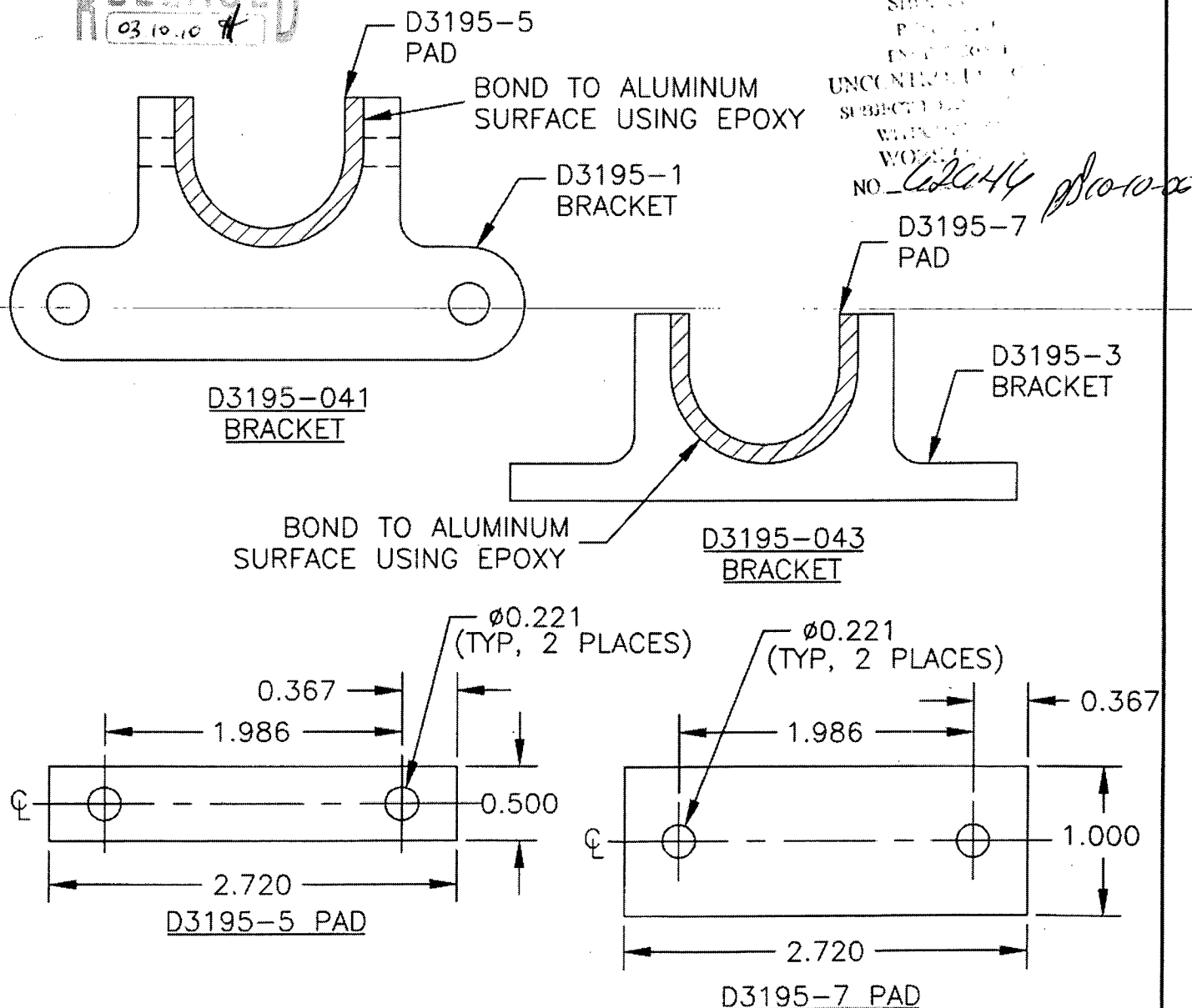
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO. D3195	REV. A SHEET 1 OF 3
DATE	03.06.23		TITLE	BRACKET	SCALE 1:1
A	03.06.23		NEW ISSUE		

RELEASED
03.10.10 *#*



D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

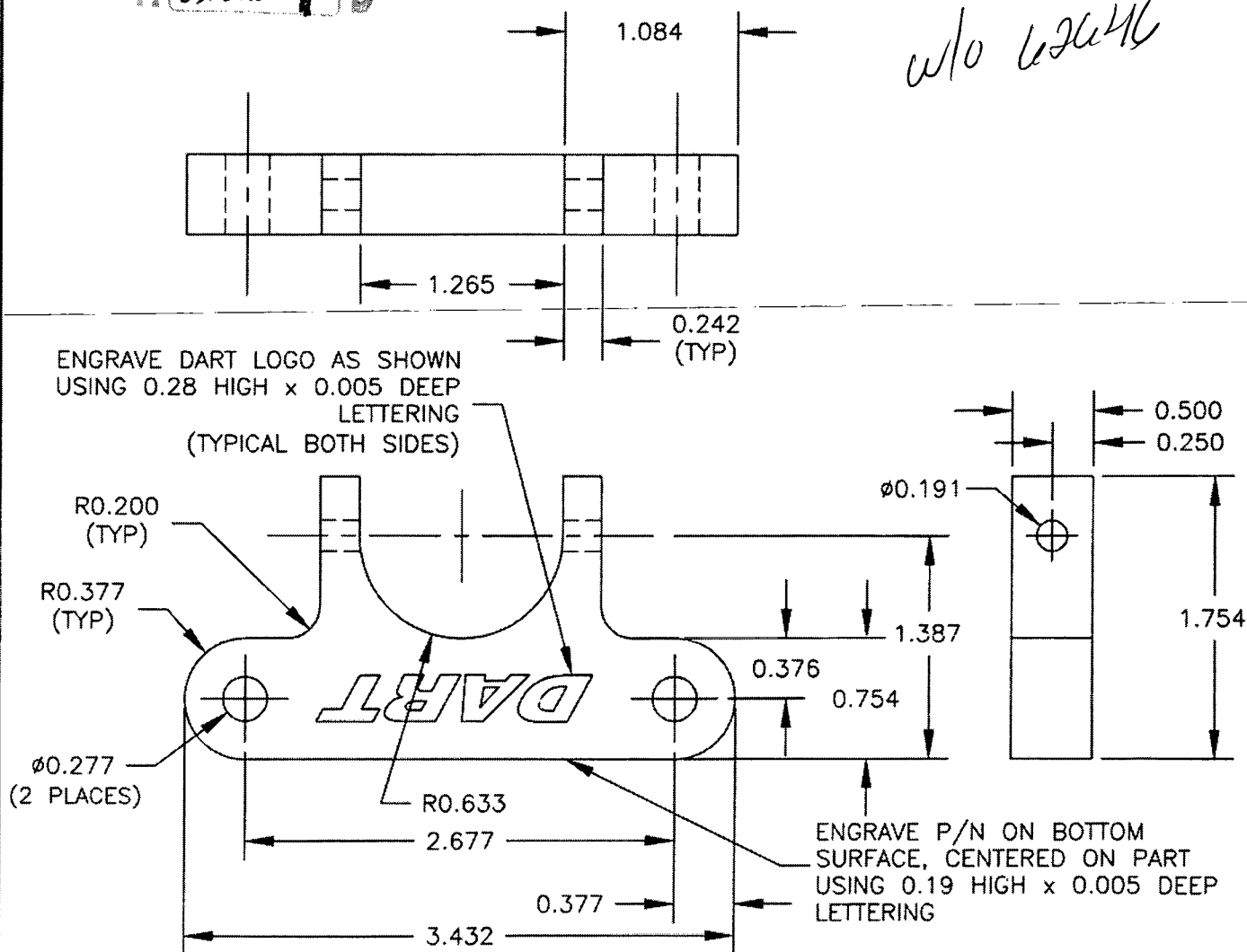
NOTE: Date & initial all entries



DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD	REV. A
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	SHEET 2 OF 3
				D3195	
DATE	03.06.23			TITLE	SCALE
				BRACKET	1:1

RELEASED
03.10.10

w/o 62646



D3195-1 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

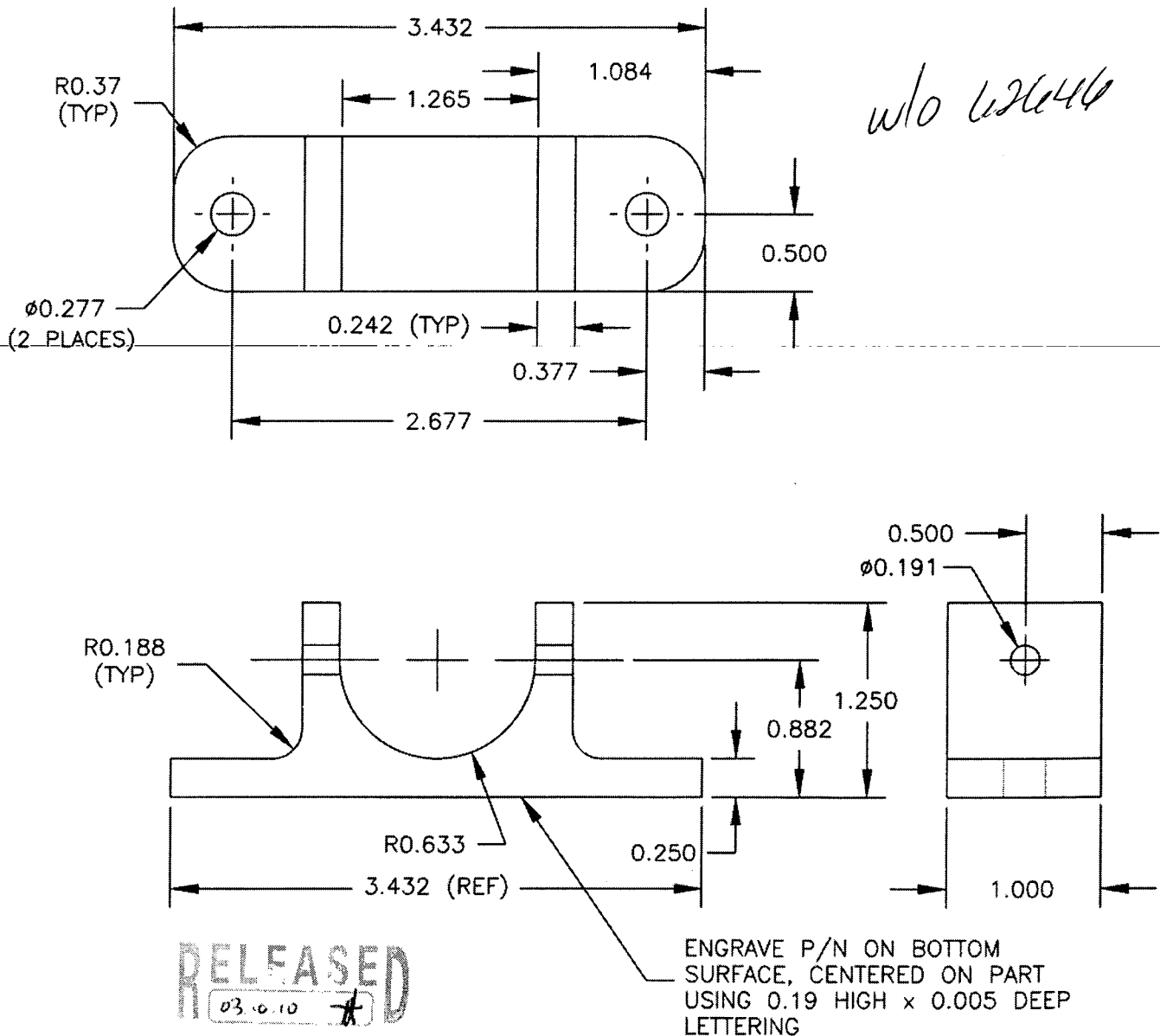
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 3 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1



D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries